

Work Order ID 69785

Page 1

Thursday, May 19, 2011 10:36:05 AM

Item ID: D4011-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Clamp, Short

Start Date: 5/19/2011 Start Qty: 50.00



Cust Item ID:

Required Date: 5/27/2011 Req'd Qty: 50.00



Customer:

Reference:

Approvals:

Process Plan: CLDate: 11/05/19

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4011

B

100

0.00



PURCHASING

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: BProg Rev: B

2-Deburr if necessary

B11-5-31EC

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-5-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8 w/05/31

counters
(+56)

130

Form as per dwg

0.00



Brake NC

NC BRAKE

Memo

0.00

Brake NC

SR 11/06/06

(56)

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 w/06/08

counters
(+56)

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Item Name: Clamp, Short

Start Date: 5/19/2011 Start Qty: 50.00



Cust Item ID:

Required Date: 5/27/2011 Req'd Qty: 50.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: 459

0.00



Packaging

Memo

0.00

Packaging

11/6/8 SP (56)

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/8 SPME
11-06-08

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Thursday, May 19, 2011 10:36:03 AM

Page 1

Work Order ID: 69785

Parent Item: D4011-5

Parent Item Name: Clamp, Short





Start Date: 5/19/2011

Required Date: 5/27/2011

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP RevA: revB as per dwg 09.11.18 DD verified by:JLM IPP
Rev:B 11.05.19 MADE IN HOUSE DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S14GA 		Purchased	No			100	sf	27.1000	0.053 	2.789474	3.		

304SS sheet .080

113-5-31

Location

Loc Qty

Loc Code

MAT020

27.1

113295

27.1

113 295

56

Dart Aerospace Ltd

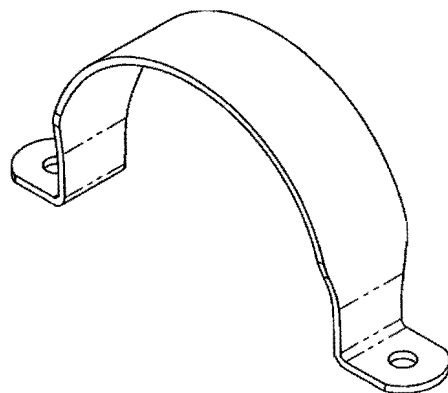
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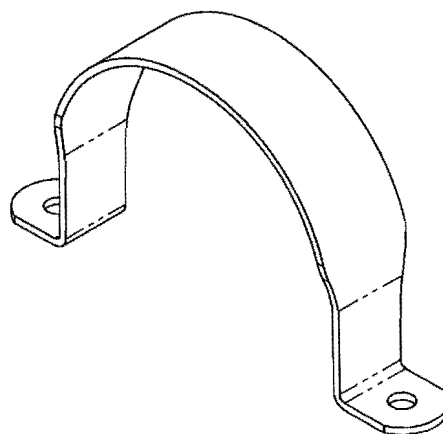
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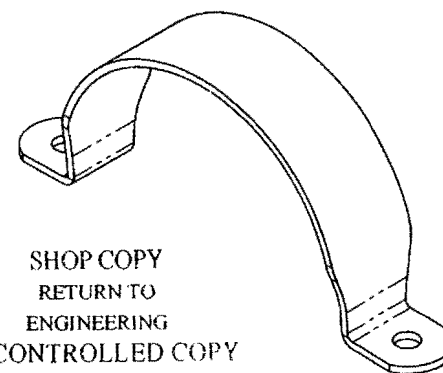
NOTE: Date & initial all entries



D4011-1 CLAMP, SHORT



D4011-3 CLAMP, LONG



D4011-5 CLAMP, SHORT (OEM)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 64785

11-05-9

RELEASED
2009-11-24
MP

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 14 GAUGE (0.078 THICK)
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S14GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4011-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.02 lbs EACH

B	SHORTEN HEIGHT OF -1/3 CLAMPS BY 0.125, ADDED -.5. REASON: PROVIDE MORE CLEARANCE UPON INSTALLATION ON OEM SKIDTUBES	MB	09.11.11
A	NEW ISSUE	MB	09.10.21
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>JS</i>		
DRAWN	<i>JS</i>		
CHECKED	<i>JS</i>		
MFG. APPR.	<i>JS</i>		
APPROVED	<i>JS</i>		
DE APPR.	<i>JS</i>		
DATE	09.11.11		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4011** REV. B
SHEET 1 OF 4

TITLE **CLAMP** SCALE
NTS

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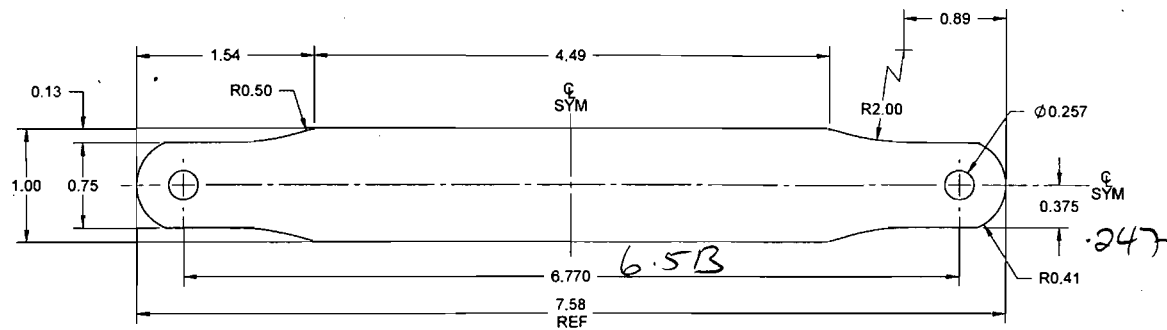
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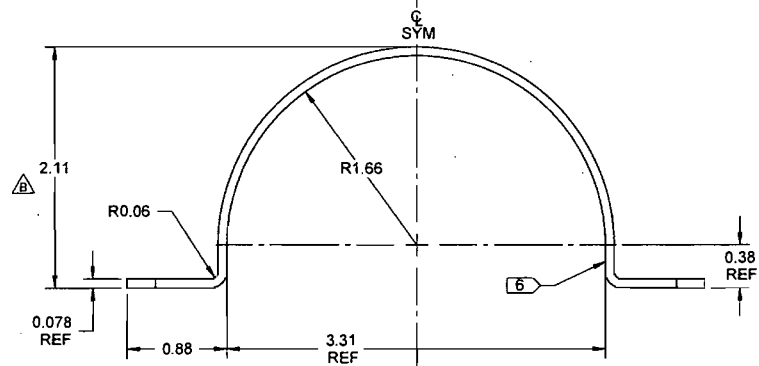
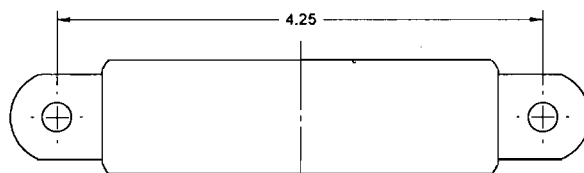
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D4011-5F CLAMP, SHORT (OEM) FLAT PATTERN



D4011-5 CLAMP, SHORT (OEM)
(MAKE FROM D4011-5F)

RELEASED
2009-11-24
MP

DESIGN	1	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	A			
CHECKED	15		DRAWING NO.	REV. B
MFG. APPR.	15		D4011	SHEET 4 OF 4
APPROVED	15		TITLE	SCALE
DE APPR.	15		CLAMP	NTS
DATE	09.11.11		COPYRIGHT © 2009 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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